

Work Order ID 112398

112398

Page 1

January-30-14 11:41:46 AM

Item ID: 647.1210 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Screen
 Start Date: 1/30/14 Start Qty: 4.00 *4* Cust Item ID:
 Required Date: 1/30/14 Req'd Qty: 4.00 *4* Customer:
 Reference:

Approvals: Process Plan: ML3 Date: 1-21-14 Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
647.1200	N/C								
110		0.00							
110									
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg Dwg Rev: <u>N/C</u> Prog Rev: <u>N/C</u> 2-Deburr if necessary								
120	QC2- Inspect parts off machine FAI/FAIB	0.00							
120									
QC	Memo	0.00							
Quality Control									

16 0 Jm14-04-18

16 0 Jm14-04-18

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
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Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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112398

Page 2

Item ID: 647.1210	Accept	*N900040100*	Setup Start	*NS1*
Revision ID:			Stop	*NS2*
Item Name: Screen				
Start Date: 1/30/14	Start Qty: 4.00	*4*	Cust Item ID:	
Required Date: 1/30/14	Req'd Qty: 4.00	*4*	Customer:	
Reference:				

Approvals:	Process Plan: _____	Date: _____	Tooling: _____	Date: _____	Run Start	*NR1*
	QC: _____	Date: _____	SPC (Y/N): _____	Date: _____	Stop	*NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130	QC8- Inspect parts - second check	0.00				16			
130									
QC	Memo	0.00							

Quality Control

140	Identify as per dwg & Stock Location: <u>81536</u>	0.00							
140									
Packaging	Memo	0.00							

Packaging

150	QC21- Final Inspection - Work Order Release	0.00							
150									
QC	Memo	0.00							

Quality Control

DMS
20
9-89

MLJ 14-04-21

Ⓜ 14-04-21

DQA: _____ Date: _____



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Work Order update only ☐

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Picklist Print

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Page 1

Work Order ID: 112398

Parent Item: 647.1210

Parent Item Name: Screen

Start Date: 1/30/14

Required Date: 1/30/14

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP REV:A 12.08.14 NEW ISSUE DD VERF:JFS

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
85385T403 Screen		Purchased	No			110	sf	0.0000	0.0434	0.1827368	0.25	Jm14-04-18	
											1 sq. FT.		

128797

128797

DQA: _____ Date: _____



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112398
MLJ
14-01-31

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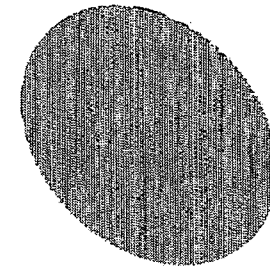
REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED
1	LAST PROTOTYPE REVISION PER:		ELC
2	INITIAL RELEASE	05/27/09	P. BRAVO

NOTES:

1 MATERIAL: STAINLESS STEEL TYPE 304 WOVEN WIRE CLOTH
MESH SIZE: 20X20
SQUARE/RECTANGLE SIZE: .034"
WIRE DIAMETER: .016"
VENDOR: MCMASTER-CARR
P/N: 85385T403

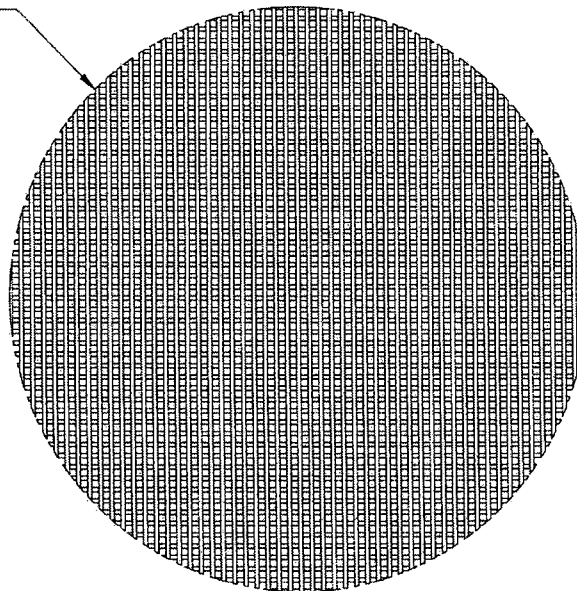
2 FINISH: NONE

3. IDENTIFY IAW MPP-120



647.1210

Ø2.50



		647.1210	SCREEN	△	△
	FIND #	PART #	DESCRIPTION	MAT'L	SPEC.
QTY		PARTS LIST			
NEXT ASSY (\$)		APICAL INDUSTRIES			
646.9500		2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92036-3512 (760) 724-5300			
		SCREEN			
		UNLESS OTHERWISE SPECIFIED: DIMENSIONS ARE IN INCHES FRACTIONS ARE: 3 PLACE DECIMALS ± .01 ANGLES ± .5°			
REV	CAGE CODE	DWG NO	REV.		
B	07/11/06	647.1200	N/C		
SCALE NONE		SHEET 1 OF 1			